

Work Order ID 150931-1

150931

Page 1

Monday, September 12, 2016 10:30:48 AM

Item ID: D350-822-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: SEP 12 2016

Tooling:

Date:

Run Start

NR1

QC: DAS 21 Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-822	F								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.01							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-822-013 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.01							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

1 DAS
27
9-89
OCT 20 20162 PC DAS
28
9-89
SEP 19 20161 DAS
27
9-89
OCT 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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				QC / QA Coordinator Approval																	
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Work Order ID 150931***150931***

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Monday, September 12, 2016 10:30:48 AM

Item ID: D350-822-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.01

Identify and pack for shipping as per PPP D350-822-013

Location: **fg**DAS
28
9-891 DAS
27
9-89

OCT 20 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.03

Quality Control

DAS
21
9-89

OCT 20 2016

DAS
21
9-89

OCT 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Picklist Print

Monday, September 12, 2016 10:30:51 AM

Page 1

Work Order ID: 150931

150931

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 16.09.01 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149D0332J

Purchased

No

Each

1,326.000

116

NAS1149D0332.J

Washer

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

204

m134848

204

GA

300

m134848

300

ST260a

600

m135566

600

ST264

216

m135536

216

23

93

650.0401

Purchased

No

Each

1.0000

650 0401

PUREair Fairing Assembly

**

1-2
132/55
OCT 20 2016
SEP 28 2016

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG109

1

m2155

1

D4925-041

Manufactured

No

Each

0.0000

D4925-041

Mounting Plate Assembly

**

1-2

B144 6-17
DAS
28
9-89

SEP 19 2016

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Page 2

Work Order ID: 150931

150931

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

D4931-1 Manufactured No

Each 5.0000

2

D4931-1

**

Engine Fitting (for acft models B2 & previous)

PC

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

st138

5

150521

5

D4931-3 Manufactured No

Each 0.0000

D4931-3

**

Engine Fitting (for B3 models)

2

2

B150445 PC

DAS 28 9-89

D4931-5 Manufactured No

Each 0.0000

D4931-5

**

Engine Fitting (for B3e models)

2

B150413 PC

DAS 28 9-89

D4935-1 Manufactured No

Each 4.0000

D4935-1

**

Mounting Bracket

12

10x150523 PC

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST139

4

146511

1

149873

3

D4943-1 Manufactured No

Each 9.0000

D4943-1

**

Flex Hose

2

PC

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST220a

8

119754

8

st220b

1

119752

1

1

1

SEP 19 2016

Monday, September 12, 2016 10:30:51 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Page 3

Work Order ID: 150931

150931

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

D4961-041

Manufactured No

Each

6.0000

1-2

D4961-041

Tube Assembly

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST139

6

150524

6

2

D4961-043

Manufactured No

Each

2.0000

1-2

D4961-043

Tube Assembly

**

PC DAS 28 9-89

AS 27 89

Location

Loc Qty

Loc Code

ST140

2

149865

2

2

D5079-1

Purchased No

Each

4.0000

0-4

D5079-1

Placard, EAPS

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST148

4

150526

4

9/7/2017

4

D5090-041

Manufactured No

Each

0.0000

1-2

D5090-041

Duct Assembly

**

146923 SEP 2 R 2016

DAS 628 9-89 9-89

D5105-1

Manufactured No

Each

8.0000

0-4

D5105-1

Handle

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

st151

8

149869

8

4

SEP 19 2016

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Shop Packet Print

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WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 4

Work Order ID: 150931

150931

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

D5110-1 Manufactured No

Each 3.0000

1 2

D5110-1

Swivel Nut Fitting

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST152

3

149879

3

2

D5179-1 Manufactured No

Each 19.0000

2 4

D5179-1

Doubler

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST220

19

149870

19

4

D5179-3 Manufactured No

Each 0.0000

2 4

D5179-3

Doubler

**

PC ISO 28 9-89

DAS 27 9-89

D5194-1 Manufactured No

Each 14.0000

2 4

D5194-1

Doubler

**

PC DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST220

14

149874

4

150530

10

4

D5208-041 Manufactured No

Each 0.0000

3 6

D5208-041

Blanking Plate Assembly

8411999090

OCT 06 2016

DAS 6 9-89

150531x2

**

3x B ISO 28 9-89

DAS 27 9-89

Purchased No

Each 0.0000

1 2

8411999090

Gasket - P/N 9752100180

**

135625 PC DAS 28 9-89

DAS 27 9-89

SEP 19 2016

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Work Order ID: 150931

150931

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

9752018044

Purchased

No

Each

10.0000

9752018044

Gasket (for B3 models)

**

1-2 DAS 28 9-89 PC

DAS 27 9-89

Location

Loc Qty

Loc Code

ST589

10

m134710

1

m135521

9

9945000120

Purchased

No

Each

10.0000

9945000120

Gasket (for B3e models)

**

1-2 DAS 28 9-89 PC

DAS 27 9-89

Location

Loc Qty

Loc Code

ST564

9

m135521

9

ST589

1

m134710

1

23350CA050

Purchased

No

Each

119.0000

23350CA050

WASHER

**

2-4 DAS 28 9-89 PC

DAS 27 9-89

Location

Loc Qty

Loc Code

ST568

19

m129609

19

ST579

100

m135603

100

AN821-12J

Purchased

No

Each

23.0000

AN821-12J

Elbow (or AN821-12K or 12S)

**

2-4 DAS 28 9-89 PC

DAS 27 9-89

Location

Loc Qty

Loc Code

OVER007

10

M135603

10

ST324

13

M135544

13

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Work Order ID: 150931

150931

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

AN929-12J

Purchased

No

Each

11.0000

1- 2

AN929-12J

Cap

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

ST322

11

m134861

2

m135544

4

m135603

5

2

DAS
27
9-89

EN3686-050016

Purchased

No

Each

0.0000

2- 4

EN3686-050016

Screw

**

135663 JC

DAS
28
9-89

LN9038-05012

Purchased

No

Each

209.0000

32- 64

LN9038-05012

Bolt

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

209

m135544

169

m135603

40

64

DAS
27
9-89

LN9038-05040

Purchased

No

Each

9.0000

1- 2

LN9038-05040

Bolt

**

PC

DAS
28
9-89

Location

Loc Qty

Loc Code

ST564

9

m134976

9

2

DAS
27
9-89

LN9348-05

Purchased

No

Each

0.0000

52

LN9348-05

Nut

**

M135651 P28

DAS
28
9-89

DAS
27
9-89

SEP 19 2016

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐		No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																			
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
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Handling/Pre ☐		Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																			
Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
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Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐		Past Due ☐																							

Picklist Print

Page 7

Monday, September 12, 2016 10:30:51 AM

Work Order ID: 150931

150931

Parent Item: D350-822-013

D350-822-013

Parent Item Name: PA100 PUREair System for AS350/EC130 - Provisions

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

MS20470AD3-4

Purchased

No

Each

810.0000

18 36

MS20470AD3-4

Rivet, Universal Head

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

268

111477

268

ST310

542

111477

542

Each

24.0000

1 2

MS21919WCH12

Purchased

No

MS21919WCH12

Clamp

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST291

24

m135536

14

m135600

10

Each

10.0000

1 2

MS9592-138

Purchased

No

MS9592-138

Bracket

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST267

10

m135544

5

m135603

5

Each

29.0000

1 2

NAS43DD3-64

Purchased

No

NAS43DD3-64

Spacer

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

5

m132461

5

ST550

24

m135603

24

SEP 19 2016

Monday, September 12, 2016 10:30:51 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D350-822-011	PA100 PUREAIR SYSTEM
	X	D350-822-013	PA100 PUREAIR PROVISIONS
1		QB05008	PUREAIR SYSTEM
1**		QR10818	TUBE REPAIR KIT
1**		QB21304	PUREAIR PANEL ASSY
1**		QB21310	TRANSITION DUCT ASSY
1**		QB21308	FOD SCREEN ASSY
15**		LN29985-A05	ANCHOR NUT
58**		LN9038-05018	BOLT
58**		BS4320-A5	WASHER
40**		MS20426AD3-3	RIVET
1	1	650.0401	PUREAIR FAIRING ASSY
1	1	D4925-041	MOUNTING PLATE ASSY
1*	1*	D4931-1	ENGINE FITTING
1*	1*	D4931-3	ENGINE FITTING
1*	1*	D4931-5	ENGINE FITTING
6	6	D4935-1	MOUNTING BRACKET
1	1	D4943-1	FLEX HOSE
1	1	D4961-041	TUBE ASSEMBLY
1	1	D4961-043	TUBE ASSEMBLY
2	2	D5079-1	PLACARD
1	1	D5090-041	DUCT ASSEMBLY
2	2	D5105-1	HANDLE
1	1	D5110-1	SWIVEL NUT FITTING
2	2	D5179-1	DOUBLER
2	2	D5179-3	DOUBLER
2	2	D5194-1	DOUBLER
3	3	D5208-041	BLANKING PLATE ASSY
1*	1*	9752100180	GASKET
1*	1*	9945000120	GASKET
2	2	23350CA050	LOCKING TAB
2	2	AN821-12J	ELBOW (OR AN821-12K OR AN821-12S)
1	1	AN929-12J	CAP
58	58	BS4320-A5	WASHER (OR NAS1149D0332J)
2	2	EN3686-050016	SCREW
32	32	LN9038-05012	BOLT
1	1	LN9038-05040	BOLT
26	26	LN9348-05	NUT
18	18	MS20470AD3-4	RIVET
1	1	MS21919WHG12	CLAMP
1	1	MS9592-138	BRACKET
1	1	NAS43DD3-64	SPACER

* USE APPROPRIATE FITTING/GASKET BASED ON ENGINE INSTALLATION

** PART OF QB05008 ABOVE